

20.21

Work Order ID 156798***156798***

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Wednesday, February 08, 2017 9:10:01 AM

Item ID: D2199-25 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Strut
 Start Date: 2/2/2017 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 2/8/2017 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: **DAS 21 9-89** Date: **FEB 08 2017** Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2199	F								
100	NC BRAKE	0.03				<u>2</u>	<u>FF</u>		FEB 21
100									
Brake NC	Memo	0.07							
Brake NC	Punch per Dwg. D2199 and Spec Control Dwg D2638								
	Deburr								
120	QC5- Inspect part completeness to step on W/O	0.00				<u>2</u>			DAS 38 9-89
120									
QC	Memo	0.01							FEB 21 2017
Quality Control									
130	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel	0.00				<u>2</u>	<u>φ 1702-22</u>	<u>338</u>	
130									
Powdercoat	Memo	0.06							
Powder Coating	START TIME: <u>11:50</u>								
	OVEN TEMPERATURE: <u>400°</u>								
	FINISH TIME: <u>12:00</u>								

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER :							

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	QC3- Inspect Part Finish	0.00				2			DAS 38 9-89
140	Memo	0.00							
QC									
Quality Control									FEB 22 2017
150	Identify as per dwg & Stock Location: <u>5135</u>	0.00				2			DAS 6 9-89
150	Memo	0.00							
Packaging									
Packaging									FEB 23 2017
160	QC21- Final Inspection - Work Order Release	0.00							DAS 21 9-89
160	Memo	0.03							
QC									
Quality Control									FEB 23 2017 MF 17-2-23

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Root Cause				FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐		
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐		
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐		
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐		
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐		
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐		
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Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐		
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____					
Misidentified ☐	Past Due ☐						

Picklist Print

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Work Order ID: 156798

156798

Parent Item: D2199-25

D2199-25

Parent Item Name: Strut

Start Date: 2/2/2017

Required Date: 2/8/2017

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 13.03.05 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TR0.750W.049		Purchased	No				f	185.6723		3.494737			
M304TR0 750W 049									**		FF	FEB 21 2017	
304 RD Tube .750 x .049W													

Location

Loc Qty

Loc Code

GA002

185.6723371

M134528

30.2105266

M134824

4.8478935

M135093

1.905367

M135242

14.0073785

M135373

16.44849

M135709

0.0790537

M135857

0.0003668

M136323

0.045893

M136667

18.127368

M136760

100

3.494737

DQA: _____ Date: _____



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